

Work Order ID 69292-1

Friday, May 06, 2011 11:55:39 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011

Start Qty: 1200



(1)

Cust Item ID:

Required Date: 5/9/2011

Req'd Qty: 1200



Customer:

Reference:

Approvals:

Process Plan:



Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3537	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

13 11-5-9

FLOW CNC Waterjet

304.063

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(15)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

13 11-5-9

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

8 most/9

13 11-5-9

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69292

Friday, May 06, 2011 11:55:40 AM



Page 2

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Accept



Setup Start



Stop



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

15

Brake NC

Memo

0.00

SB 11/05/09

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

140



QC5- Inspect part completeness to step on W/O

0.00

SW 05/09

70

QC

Quality Control

Memo

Ensure joggle as per dwg D3429

150



Large Fab

0.00

CZ 146-9

X1

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
M117659 Weld hardcoat as per Dwg D3437

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
							/	

NOTE: Date & initial all entries

Work Order ID 69292

Friday, May 06, 2011 11:55:40 AM



Page 3

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 5/6/2011 Start Qty: 12.00

Accept



Setup Start



Required Date: 5/9/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

S woblog

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

S woblog

180



Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00

0.00

Memo

1-20

START TIME

DOVEN TEMPERATURE:

FINISH TIME:

1-50

M115128

X S m-11/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 69292

Page 4

Friday, May 06, 2011 11:55:40 AM

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

QC3- Inspect Part Finish

0.00

1

4 1106104

Quality Control

200



Packaging

Identify as per dwg & Stock Location: *FP. 1*

0.00

1

4 1106109

Packaging

210



QC

QC21- Final Inspection - Work Order Release

0.00

1

11/6/09

Quality Control

Memo

0.00

1

ENF
11-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:55:48 AM

Page 1

Work Order ID: 69292



Parent Item: D3537-3



Parent Item Name: Wearpad

Start Date: 5/6/2011

Required Date: 5/9/2011

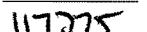
Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	98.5000	0.149	1.882105	 2.5 R311-5-9		

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020:	98.5	
117275	98.5	 117275

(K)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	69292
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>11-5-9</u>	Date: <u>11/05/09</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

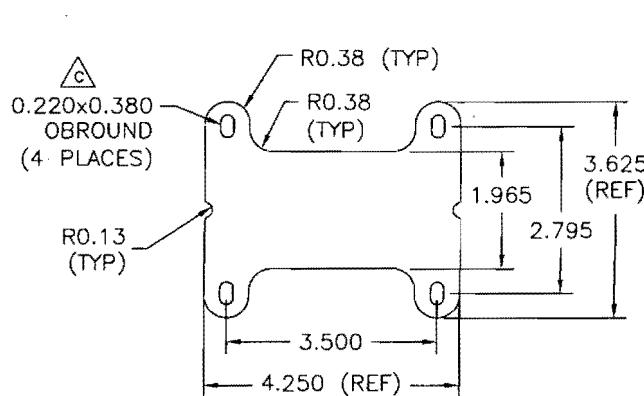
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

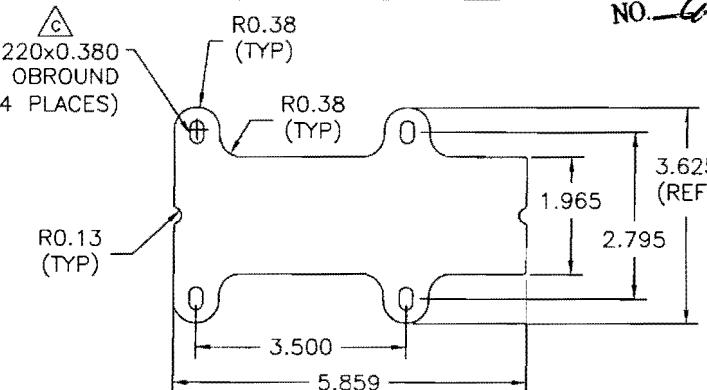
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69292*

PL11-05-4

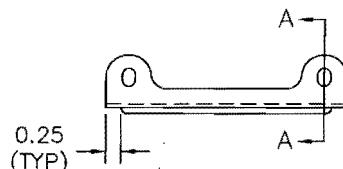
D3537-1F FLAT PATTERN



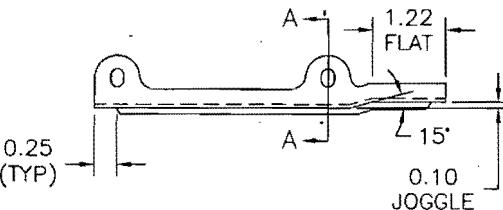
D3537-3F FLAT PATTERN



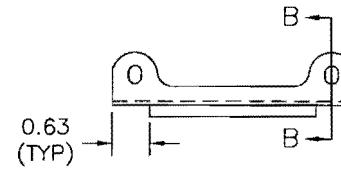
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HUDDLE, MA
CHECKED	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
DATE	TITLE	SCALE 1:2
07.04.13	WEARPAD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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